

Work Order ID 135928

Tuesday, August 25, 2015 8:10:52 AM

135928*Black N/A*

Page 1

Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, In
Start Date: 8/24/2015 Start Qty: 14.00 ***14*** Cust Item ID:
Required Date: 9/11/2015 Req'd Qty: 14.00 ***14*** Customer:
Reference:

Approvals: Process Plan: MLS Date: AUG 25 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2574	F								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.09

HAAS CNC vertical machine #1

Program Batch No. 135928Double check by: [Signature]

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

14 φ JFC 2015-09-10
P.T.O.

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.01

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

14 φ JFC 2015-9-22
amr 15/09/24

DQA: AWT Date: 15/10/19

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: [Signature] Date: 15/10/08Work Order update only ☐

Work Order: <u>135928</u> Part No. <u>D2574</u> NCR No. <u>15-5889</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date: <u>15-09-23</u>	Step #: <u>100</u>	QTY Effective: <u>1</u>	MRB (QSI042) Approval <u>A.P.</u> <u>15.09.23</u>																																																																
Description Work Order Deviation Dimension .313 $\pm .005$ is uneven with two location that measure .303 PC. operator buff too much material.		Disposition ACCEPTABLE LOCAL DAMAGE AREA LESS THAN $\varnothing 0.150$, ENSURE SMOOTH TRANSITION TO ENSURE STRESS FLOW THROUGH MATERIAL.																																																																	
		Completed By <u>JFC</u> <u>2015-9-23</u> Lead hand / Supervisor Approval Verification <u>DAS</u> <u>08</u> <u>9-89</u> <u>Y.A 15/09/23</u> QC / QA Coordinator Approval <u>DAS</u> <u>9</u> <u>9-89</u> <u>1509.23</u>																																																																	
Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☒</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☒	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☒</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>		Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☒	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 135928

Tuesday, August 25, 2015 8:10:52 AM

135928

Page 3

Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, In
Start Date: 8/24/2015 Start Qty: 14.00 ***14*** Cust Item ID:
Required Date: 9/11/2015 Req'd Qty: 14.00 ***14*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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155

Spray Painting per QSI005 4.2

0.00

155Spray Paint
Spray Painting**Memo**

0.00

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

1-Prime inside & outside crosstube as per QSI 005 4.2

BATCH: _____

2- After painting remove masking and apply matte clear coat per QSI005 4.2

BATCH: _____

3- MASK UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING

4 -Paint Outside of Tube as per Dart QSI 005 4.7.2

ATTN: BLACK ALUMIGRIP

P/N 4200SHR90009

BATCH: _____

5 - 656-58-9000/X503 semi gloss clear

BATCH: _____

14 0 15-10-1 34 0.00

15-10-01

Powdercoat As Per QSI / Drawing

m 132729.

START: 1:45.

OVEN, T: 300°

FINISH: 2:15.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 135928

Tuesday, August 25, 2015 8:10:52 AM

135928

Page 4

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
156 *156* QC Quality Control	QC14- Inspect Spray Paint Memo QC3 15-01	0.00 0.00				(24)			QB 15-10-01
170 *170* Packaging Packaging	Identify as per dwg & Stock Location St 398 Memo	0.00 0.00				14	9107	27 9-89	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02				MLJ		OCT 05 2015	

MLJ OCT 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, August 25, 2015 8:10:56 AM

Page 1

Work Order ID: 135928

135928

Parent Item: D2574

D2574

Parent Item Name: Saddle, Aft, In

Start Date: 8/24/2015

Required Date: 9/11/2015

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			110	Each	16.0000	1	14			

D6101-005

Saddle Billet

Location

Loc Qty

Loc Code

MAT041

16

128411

1

131758

1

134039

14

14 JFC 2015-09-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

petite

DART AEROSPACE LTD	Work Order:	135928
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.005	8.003	8.003		
F	0.490	0.510		0.498	0.494	0.499	0.500		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.498	0.501	0.501	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.572	0.572	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.130	0.130	0.130		
Q	0.115	0.135		0.124	0.125	0.125	0.125		
R	0.240	0.260		0.250	0.250	0.250	0.250		
S	0.115	0.135		0.129	0.129	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.236	0.236	0.235		
W	0.115	0.135		0.134	0.133	0.132	0.132		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.368	0.368	0.366	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.625	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.250	0.250	0.250		
AE	1.500	1.520		1.510	1.512	1.513	1.512		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.246	0.246	0.248	0.249		
AI	2.000	2.020		2.000	2.003	2.003	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	JFC
Date:	2015-09-15

Audited by:	A.D.	DAS
Date:	15/10/01	08

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

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DART AEROSPACE LTD	Work Order: 135928
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.003	8.004		
F	0.490	0.510		0.498	0.497	0.499	0.501		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.498	0.499	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.567	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.130	0.130	0.130		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.250	0.250	0.250	0.250		
S	0.115	0.135		0.128	0.128	0.129	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.235	0.239	0.241	0.240		
W	0.115	0.135		0.132	0.133	0.133	0.133		
X	0.307	0.312		0.310	0.307	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.367	0.368	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.624	0.625	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.250	0.250	0.248		
AE	1.500	1.520		1.513	1.514	1.514	1.513		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.247	0.249	0.246		
AI	2.000	2.020		2.0025	2.003	2.003	2.0024		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: JFC
Date: 2015-09-16

Audited by: LA	BAS
Date: 15/10/01	08
	9-88

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

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DART AEROSPACE LTD	Work Order: 135928
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	311	412		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		0.502	0.501	0.502	0.502		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.568	0.570	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.130	0.130	0.130		
Q	0.115	0.135		0.125	0.125	0.129	0.129		
R	0.240	0.260		0.252	0.252	0.252	0.252		
S	0.115	0.135		0.129	0.128	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.241	0.241	0.241		
W	0.115	0.135		0.133	0.133	0.133	0.133		
X	0.307	0.312		0.310	0.310	0.310	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.368	0.368	0.368	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.625	0.625	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.250	0.249	0.251		
AE	1.500	1.520		1.5135	1.519	1.5128	1.5124		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.246	0.248	0.248	0.248		
AI	2.000	2.020		2.0015	2.002	2.0005	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: JFC	Audited by: D. n	DAS
Date: 2015-04-21 15/09/24	Date: 15/10/01	08 9-88

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

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DART AEROSPACE LTD	Work Order: 135928
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

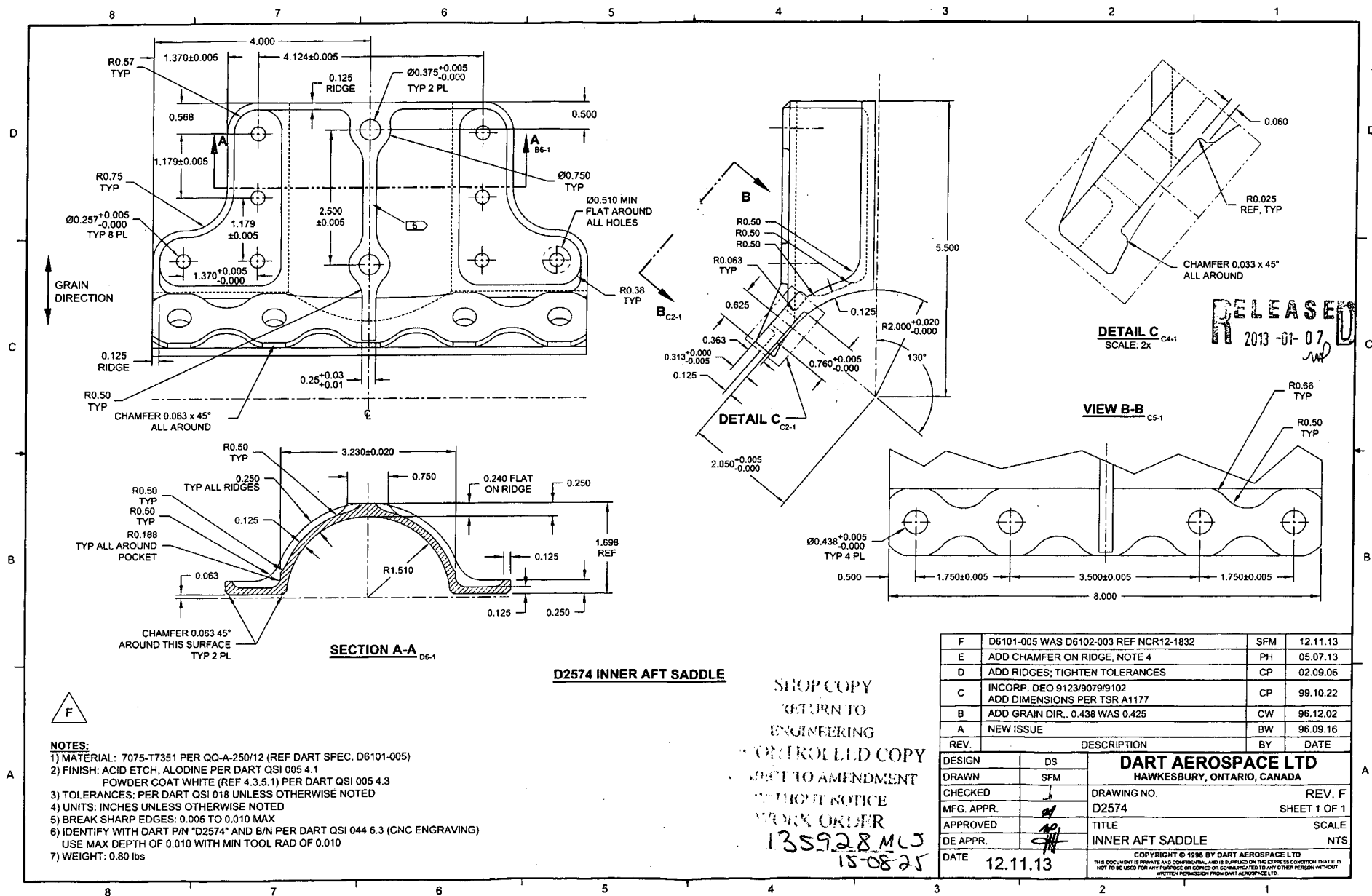
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	A13	A14	A	A		
A	0.438	0.443		0.440	0.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.004	8.005				
F	0.490	0.510		0.499	.499				
G	0.257	0.262		0.260	0.260				
H	0.375	0.380		0.376	0.376				
I	0.490	0.510		0.500	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		0.568	.568				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		0.130	0.130				
Q	0.115	0.135		0.124	.124				
R	0.240	0.260		0.253	.253				
S	0.115	0.135		0.130	.128				
T	0.178	0.198		0.188	0.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		0.240	.238				
W	0.115	0.135		0.134	.134				
X	0.307	0.312		.312	.312				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.368	.365				
AA	0.470	0.530		0.502	0.502				
AB	0.615	0.635		0.625	.623				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.247	.248				
AE	1.500	1.520		1.513	1.514				
AF	0.115	0.135		0.128	0.128				
AG	0.240	0.280		0.260	0.260				
AH	0.240	0.260		0.248	.246				
AI	2.000	2.020		2.001	2.002				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									

Measured by: JFC	OMP
Date: 2005-09-22	15/09/24

Audited by: D.F.	DAS
Date: 15/10/01	08
	9-09

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



RELEASE
2013-01-07